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ABSTRACT:

A disposable substantially damp cleansing article is disclosed having a cleansing composition impregnated onto a flexible substrate such as a non-woven cloth. The impregnated compositions include lathering surfactants and water, and a water-binding agent resulting in a composition having a water activity less than 0.977 but no lower than 0.001. Amounts of water range from greater than 15% to no higher than 40% by weight of the total article. Speed of lather formation and foam volume increases within the window of the stated water activity and water range.

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(54) Title: **DAMP CLEANSING WIPE**

(57) Abstract: A disposable substantially damp cleansing article is disclosed having a cleansing composition impregnated onto a flexible substrate such as a non-woven cloth. The impregnated compositions include lathering surfactants and water, and a water-binding agent resulting in a composition having a water activity less than 0.977 but no lower than 0.001. Amounts of water range from greater than 15% to no higher than 40% by weight of the total article. Speed of lather formation and foam volume increases within the window of the stated water activity and water range.

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DAMP CLEANSING WIPE

The invention concerns low-cost, easily manufacturable disposable single use, substantially damp, cleansing articles.

5 Personal cleansing and conditioning products have traditionally been marketed in a variety of forms such as bar soaps, creams, lotions, and gels. These formulations have attempted to satisfy a number of criteria to be acceptable to consumers. These criteria include cleansing  
10 effectiveness, skin feel, skin mildness and lather volume. Ideal personal cleansers should gently cleanse the skin or hair, cause little or no irritation, and not leave the skin or hair overly dry after frequent use.

A series of granted and pending patent applications have  
15 been published by Procter & Gamble describing disposable personal cleansing products purportedly addressing many of the aforementioned functionality concerns. These products are substantially dry articles having deposited onto a woven or non-woven cloth a cleansing composition of surfactant,  
20 structurant, skin conditioning agent and other performance ingredients. The term "substantially dry" is defined in most of these documents as maximum 10%, but in some instances as high as 15% water. Particularly preferred levels are 5% or less. A commercial embodiment sold in the  
25 U.S. is Olay<sup>®</sup> Daily Facial Cleansing Cloths having water levels of 3-4% by weight of the total cloth article. The technology is described in the following patents.

U.S. Patent 5,951,991 (Wagner et al.) focuses on providing the substrate with a conditioning emulsion separately impregnated from the lathering surfactant onto the cloth substrate. U.S. Patent 5,980,931 (Fowler et al.) emphasizes impregnation of  
5 oil soluble conditioning agents. WO 99/55303 (Albacarys et al.) describes skin care actives formulated with the cleansing composition.

Manufacturing processes for these products are reported in U.S. Patent 5,952,043 and U.S. Patent 5,863,663, both to  
10 Mackey et al. These patents teach use of a continuous lipid phase with a high melting waxy material deposited onto the wipe substrate. The material is intended to be sufficiently brittle so as to be easily disrupted by low shear contact (e.g. during wiping of the skin) to readily release an  
15 internal skin conditioning phase, yet the material is required to be sufficiently tough to avoid premature release of the internal phase during the rigors of processing. A problem with this technology is that through compromise the continuous external lipid phase/internal polar phase is  
20 neither sufficiently robust for processing and handling nor sufficiently releasable under wash conditions to allow efficient release of conditioning agent onto the skin.

More recent publications in this area include WO 01/08542 A1 (Cen et al.), WO 01/08655 A1 (Phipps et al.), WO 01/08656 A1  
25 (Smith et al.), WO 01/08657 A1 (Lorenzi et al.) and WO 01/08658 A1 (Cawkwell et al.), all to Procter and Gamble. These documents extend the wipe technology to bonded double layer substrates of contrasting textural properties. A rougher of the two sides may act as a gripping surface while  
30 the other may be used for delivering cleansing aids. The

articles are described as being substantially dry defined as  
a Moisture Retention ratio of less than 0.95 gms. The ratio  
reports weight for total non-bound liquids in the article  
but is not synonymous with water content. Water levels are  
5 not defined.

Our evaluations of dry wipes produced by the known  
technology has indicated slow latherability. We attribute  
the problem to the relatively low water content. A need  
exists for a cleansing wipe of improved foamability and one  
10 which can be efficiently manufactured.

Accordingly, it is an advantage of the present invention to  
provide a disposable cleansing product which upon contact  
with water rapidly lathers and generates a rich long lasting  
foam.

15 Another advantage of the present invention is to provide a  
disposable cleansing product having a cleansing composition  
coatable onto a flexible wiping cloth in a process that  
minimizes foam generation during manufacture.

Still another advantage of the present invention is to  
20 provide a disposable cleansing product which may include an  
impregnated composition allowing for improved  
manufacturability, better aesthetics and increased  
latherability.

These and other advantages of the present invention will  
25 become more apparent in light of the following summary and  
disclosure.

A substantially damp cleansing product is provided which includes:

- (i) a water insoluble substrate; and
- (ii) a cleansing composition impregnated onto  
5 the substrate including:

- (a) at least one lathering surfactant  
present in an amount sufficient to  
foam;

- (b) water; and

10 wherein the water is present at greater than 15% by weight of the product, but no higher than 40%, and a water-binding agent is present in an amount sufficient to result in a composition having a water activity less than 0.977 but no lower than 0.001.

15 Now it has been found that improved lather quality/stability, foam height and imparted skinfeel is achieved through the presence of a water-binding agent in such amounts which would lower water activity to a range from less than 0.977, preferably less than about 0.96, more  
20 preferably less than about 0.94 and optimally less than about 0.90. Water activity should be at least 0.001, preferably at least about 0.50, and optimally greater than about 0.80.

Illustrative water-binding agents are polyols and inorganic  
25 salts. The polyols include glycols, polyglycols, saccharides and polysaccharides. Typical polyols include glycerol (also known as glycerin), polyalkylene glycols and

more preferably alkylene polyols and their derivatives, including propylene glycol, dipropylene glycol, polypropylene glycol, polyethylene glycol and derivatives thereof, sorbitol, hydroxypropyl sorbitol, hexylene glycol,  
5 1,3-butylene glycol, 1,2,6-hexanetriol, ethoxylated glycerol, propoxylated glycerol and mixtures thereof.

For best results the water-soluble binding agent is preferably glycerin. Also particularly preferred are polyethylene glycol (average molecular weight ranging from  
10 about 200 to about 2,000,000, with PEG-9M and PEG-14M being preferred) and hexylene glycol. In certain types of compositions the latter binding agent may be inappropriate and therefore polyols other than hexylene glycol should be utilized.

15 Saccharides useful as binding agents for purposes of this invention include dextrose, sucrose, mannose, lactose and fructose and functionalized derivatives thereof including key C<sub>1</sub>-C<sub>40</sub> alkyl esters, alkyl ethers, sulphates, carboxylates and phosphate derivatives.

20 Among the suitable inorganic salts are the alkali metal, ammonium, alkaline earth and other metal salts of halides, phosphates, sulphates and any combinations thereof. Particularly preferred is sodium chloride as an inorganic binding agent.

25 The amount of water-soluble binding agent may range anywhere from about 0.1 to about 60%, preferably from about 1 and about 30% by weight of the composition.

Water activity is defined as the vapor pressure of water in a system relative to the vapor pressure of pure water at the same temperature. It is also the equilibrium relative humidity of the air surrounding the system at the same  
5 temperature. A product with no "free" water will have a water activity of 0.000. A product such as a pure water coated towelette will have a water activity of 1.000. An instrument for direct measurement of water activity is sold under the name of AquaLab by Decagon Devices Inc., of  
10 Pullman, Washington.

The cleansing products of the present invention may have a water content ranging from greater than 15% to about 40%, preferably from about 20% to about 35%, and optimally from about 25% to about 30% by weight of the cleansing product.

15 Further, the impregnated compositions used in the present invention will have a viscosity ranging from about 70 to about 300,000 cp (centipoise). Thickness is measured on a Haake CV 20 Rheometer with 30 mm profiled parallel plates at 23°C. A preferred viscosity range is from about 100 to  
20 about 250,000 cp, more preferably from about 150 to about 100,000, even more preferably from about 200 to about 50,000 cp, and optimally from about 400 to about 1,000 cp.

An essential element of compositions according to the present invention is a lathering surfactant. By a  
25 "lathering surfactant" is meant a surfactant, which when combined with water and mechanically agitated generates a foam or lather. Preferably, these lathering surfactants should be mild, which means that they must provide sufficient cleansing or deterative benefits but not overly



dry the skin or hair, and yet meet the lathering criteria described above.

The products of the present invention typically include at least one lathering surfactant in an amount from about 0.5%  
5 to about 60%, preferably from about 0.75% to about 40%, and more preferably from about 1% to about 20%, based on the weight of the impregnated composition.

A wide variety of lathering surfactants are useful herein and include those selected from the group consisting of  
10 anionic, nonionic, cationic, amphoteric and lathering surfactant mixtures thereof.

Among the anionic lathering surfactants useful herein are the following non-limiting examples which include the classes of:

15 (1) Alkyl benzene sulfonates in which the alkyl group contains from 9 to 15 carbon atoms, preferably 11 to 14 carbon atoms in straight chain or branched chain configuration. Especially preferred is a linear alkyl benzene sulfonate  
20 containing about 12 carbon atoms in the alkyl chain.

(2) Alkyl sulfates obtained by sulfating an alcohol having 8 to 22 carbon atoms, preferably 12 to 16 carbon atoms. The alkyl sulfates have the  
25 formula  $\text{ROSO}_3\text{-M}^+$  where R is the  $\text{C}_{8-22}$  alkyl group and M is a mono- and/or divalent cation.

(3) Paraffin sulfonates having 8 to 22 carbon atoms, preferably 12 to 16 carbon atoms, in the alkyl moiety. These surfactants are commercially available as Hostapur SAS from Hoechst Celanese.

5 (4) Olefin sulfonates having 8 to 22 carbon atoms, preferably 12 to 16 carbon atoms. Most preferred is sodium C<sub>14</sub>-C<sub>16</sub> olefin sulfonate, available as Bioterge AS 40<sup>®</sup>

10 (5) Alkyl ether sulfates derived from an alcohol having 8 to 22 carbon atoms, preferably 12 to 16 carbon atoms, ethoxylated with less than 30, preferably less than 12, moles of ethylene oxide. Most preferred is sodium lauryl ether sulfate formed from 2 moles average ethoxylation,  
15 commercially available as Standapol ES-2<sup>®</sup>.

(6) Alkyl glyceryl ether sulfonates having 8 to 22 carbon atoms, preferably 12 to 16 carbon atoms, in the alkyl moiety.

(7) Fatty acid ester sulfonates of the formula:  
20  $R^1CH(SO_3-M^+)CO_2R^2$  where R<sup>1</sup> is straight or branched alkyl from about C<sub>8</sub>- to C<sub>18</sub>, preferably C<sub>12</sub> to C<sub>16</sub>, and R<sup>2</sup> is straight or branched alkyl from about C<sub>1</sub> to C<sub>6</sub>, preferably primarily C<sub>1</sub>, and M<sup>+</sup> represents a mono- or divalent cation.

(8) Secondary alcohol sulfates having 6 to 18, preferably 8 to 16 carbon atoms.

(9) Fatty acyl isethionates having from 10 to 22 carbon atoms, with sodium cocoyl isethionate being preferred.

(10) Dialkyl sulfosuccinates wherein the alkyl groups range from 3 to 20 carbon atoms each.

(11) Alkanoyl sarcosinates corresponding to the formula  $RCON(CH_3)CH_2CH_2CO_2M$  wherein R is alkyl or alkenyl of about 10 to about 20 carbon atoms and M is a water-soluble cation such as ammonium, sodium, potassium and trialkanolammonium. Most preferred is sodium lauroyl sarcosinate.

(12) Alkyl lactylates wherein the alkyl groups range from 8 to 12 carbon atoms, with sodium lauroyl lactylate sold as Pationic 138C<sup>®</sup> available from the Patterson Chemical Company as the most preferred.

(13) Taurates having from 8 to 16 carbon atoms, with cocoyl methyl taurate being preferred.

Nonionic lathering surfactants suitable for the present invention include C<sub>10</sub>-C<sub>20</sub> fatty alcohol or acid hydrophobes condensed with from 2 to 100 moles of ethylene oxide or propylene oxide per mole of hydrophobe; C<sub>2</sub>-C<sub>10</sub> alkyl phenols condensed with from 2 to 20 moles of alkylene oxides; mono- and di- fatty acid esters of ethylene glycol such as ethylene glycol distearate; fatty acid monoglycerides;

sorbitan mono- and di- C<sub>8</sub>-C<sub>20</sub> fatty acids; and polyoxyethylene sorbitan available as Polysorbate 80 and Tween 80<sup>®</sup> as well as combinations of any of the above surfactants.

- 5 Other useful nonionic surfactants include alkyl polyglucosides, saccharide fatty amides (e.g. methyl gluconamides) as well as long chain tertiary amine oxides. Examples of the latter category are: dimethyldodecylamine oxide, oleyldi(2-hydroxyethyl)amine oxide,
- 10 dimethyloctylamine oxide, dimethyldecylamine oxide, dimethyltetradecylamine oxide, di(2-hydroxyethyl)tetradecylamine oxide, 3-didodecyloxy-2-hydroxypropyldi(3-hydroxypropyl)amine oxide, and dimethylhexadecylamine oxide.
- 15 Amphoteric lathering surfactants useful for the present invention include aliphatic secondary and tertiary amines, preferably wherein the nitrogen is in a cationic state, in which the aliphatic radicals can be straight or branched chain and wherein one of the radicals contains an ionizable
- 20 water solubilizing group such as carboxy, sulphonate, sulphate, phosphate or phosphonate. Illustrative substances are cocamidopropyl betaine, cocamphoacetate, cocamphodiacetate, cocamphopropionate, cocamphodipropionate, cocamidopropyl hydroxysultaine, cetyl dimethyl betaine,
- 25 cocamidopropyl PG-dimonium chloride phosphate, coco dimethyl carboxymethyl betaine, cetyl dimethyl betaine and combinations thereof.

For purposes of the present invention, the total of all lathering surfactants to water may be in a weight ratio ranging from about 1:10 to about 5:1, preferably from about 1:4 to about 4:1, more preferably from about 1:3 to about 3:1, and optimally from about 1:2 to about 2:1.

A necessary element of the present invention is that of a water insoluble substrate. By "water insoluble" is meant the substrate does not dissolve or readily break apart upon immersion in water. A wide variety of materials can be used as the substrate. The following non-limiting characteristics are desirable: (i) sufficient wet strength for use, (ii) sufficient abrasivity, (iii) sufficient loft and porosity, (iv) sufficient thickness, and (v) appropriate size.

Non-limiting examples of suitable insoluble substrates which meet the above criteria include non-woven substrates, woven substrates, hydro-entangled substrates, air entangled substrates and the like. Preferred embodiments employ non-woven substrates since they are economical and readily available in a variety of materials. By non-woven is meant that the layer is comprised of fibers which are not woven into a fabric but rather are formed into a sheet, particularly a tissue. The fibers can either be random (i.e., randomly aligned) or they can be carded (i.e. combed to be oriented in primarily one direction). Furthermore, the non-woven substrate can be composed of a combination of layers of random and carded fibers.

Non-woven substrates may be comprised of a variety of materials both natural and synthetic. By natural is meant

that the materials are derived from plants, animals, insects or byproducts. By synthetic is meant that the materials are obtained primarily from various man-made materials or from material that is usually a fibrous web comprising any of the  
5 common synthetic or natural textile-length fibers, or mixtures thereof.

Non-limiting examples of natural materials useful in the present invention are silk fibers, keratin fibers and cellulosic fibers. Non-limiting examples of keratin fibers  
10 include those selected from the group consisting of wool fibers, camel hair fibers, and the like. Non-limiting examples of cellulosic fibers include those selected from the group consisting of wood pulp fibers, cotton fibers, hemp fibers, jute fibers, flax fibers, and mixtures thereof.

15 Non-limiting examples of synthetic materials useful in the present invention include those selected from the group consisting of acetate fibers, acrylic fibers, cellulose ester fibers, modacrylic fibers, polyamide fibers, polyester fibers, polyolefin fibers, polyvinyl alcohol fibers, rayon  
20 fibers and mixtures thereof. Examples of some of these synthetic materials include acrylics such as Acrilan<sup>®</sup>, Creslan<sup>®</sup>, and the acrylonitrile-based fiber, Orlon<sup>®</sup>; cellulose ester fibers such as cellulose acetate, Arnel<sup>®</sup>, and Acele<sup>®</sup>; polyamides such as Nylons (e.g., Nylon 6, Nylon  
25 66, and Nylon 610); polyesters such as Fortrel<sup>®</sup>, Kodel<sup>®</sup>, and Dacron<sup>®</sup>; polyolefins such as polypropylene, polyethylene; polyvinyl acetate fibers and mixtures thereof.

Non-woven substrates made from natural materials consist of webs or sheets most commonly formed on a fine wire screen from a liquid suspension of the fibers.

Substrates made from natural materials useful in the present invention can be obtained from a wide variety of commercial sources. Non-limiting examples of suitable commercially available paper layers useful herein include Airtex<sup>®</sup>, an embossed airlaid cellulosic layer having a base weight of about 77.6 gsm (71 gsy), available from James River Corporation, Green Bay, WI; and Walkisoft<sup>®</sup>, an embossed airlaid cellulosic having a base weight of about 82.0 gsm (75 gsy), available from Walkisoft U.S.A., Mount Holly, NC.

Non-woven substrates made from synthetic material useful in the present invention can also be obtained from a wide variety of commercial sources. Non-limiting examples of suitable non-woven layer materials useful herein include HFE- 40-047, an apertured hydroentangled material containing about 50% rayon and 50% polyester, and having a basis weight of about 47.0 gsm (43 grams per square yard (gsy)), available from Vertec, Inc., Walpole, MA; HEF 140-102, an apertured hydro-entangled material containing about 50% rayon and 50% polyester, and having a basis weight of about 61.2 gsm (56 gsy), available from Veratec, Inc., Walpole, MA; Novenet<sup>®</sup> 149-191, a thermo-bonded grid patterned material containing about 69% rayon, about 25% polypropylene, and about 6% cotton, and having a basis weight of about 109.4 gsm (100 gsy), available from Veratec, Inc., Walpole, MA; HEF Nubtex<sup>®</sup> 149-801, a nubbed, apertured

hydro-entangled material, containing about 100% polyester,  
and having a basis weight of about 76.6 gsm (70 gsy),  
available from Veratec, Inc. Walpole, MA; Keybak<sup>®</sup> 951V, a  
dry formed apertured material, containing about 75% rayon,  
5 about 25% acrylic fibers, and having a basis weight of about  
47.0 gsm (43 gsy), available from Chicopee Corporation, New  
Brunswick, NJ; Keybak<sup>®</sup> 1368, an apertured material,  
containing about 75% rayon, about 5% polyester, and having a  
basis weight of about 42.7 gsm (39 gsy), available from  
10 Chicopee Corporation, New Brunswick, NJ; Duralace<sup>®</sup> 1236, an  
apertured, hydro-entangled material, containing about 100%  
rayon, and having a basis weight from about 43.8 gsm (40  
gsy) to about 125.8 gsm (115 gsy), available from Chicopee  
Corporation, New Brunswick, NJ; Duralace<sup>®</sup> 5904, an  
15 apertured, hydro-entangled material, containing about 100%  
polyester, and having a basis weight from about 43.7 gsm (40  
gsy) to about 125.8 gsm (115 gsy), available from Chicopee  
Corporation, New Brunswick, NJ; Sontaro<sup>®</sup> 8868, a hydro-  
entangled material, containing about 50% cellulose and about  
20 50% polyester, and having a basis weight of about 65.6 gsm  
(60 gsy), available from Dupont Chemical Corp.

Most preferred as a substrate for purposes of this invention  
are non-woven substrates, especially blends of  
rayon/polyester and ratios of 10:90 to 90:10, preferably  
25 ratios of 20:80 to 80:20, optimally 40:60 to 60:40 by  
weight. A most useful substrate is a 70:30 rayon/polyester  
non-woven wipe article.



Anywhere from 1 to 100, preferably from 5 to 50 single wipes may be stored within a dispensing pouch or container, preferably a moisture impermeable pouch or container. During storage and between dispensing, the pouch or  
5 container is preferably resealable. Single wipe containing pouches may also be employed.

The water insoluble substrates of the present invention can comprise two or more layers, each having a different texture and abrasiveness. The differing textures can result from  
10 the use of different combinations of materials or from the use of a substrate having a more abrasive side for exfoliation and a softer, absorbent side for gentle cleansing. In addition, separate layers of the substrate can be manufactured to have different colors, thereby  
15 helping the user to further distinguish the surfaces. Although the present invention may be suitable for substrates with two or more layers having different texture and abrasiveness, the best effectiveness of the damp system can be found with single or multiple layered substrates of  
20 identical construction.

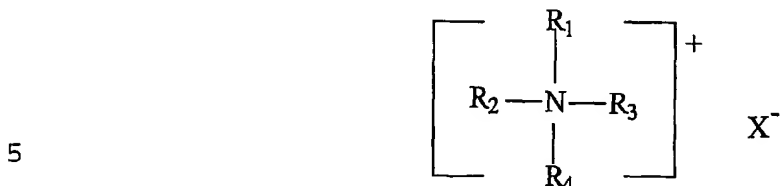
The amount of impregnating composition relative to the substrate may range from about 20:1 to 1:20, preferably from 10:1 to about 1:10 and optimally from about 2:1 to about 1:2 by weight.

25 Impregnating compositions of the present invention may also include silicones of a volatile and non-volatile variety. Typical volatile silicones are the cyclomethicones commercially available as Dow Corning 244, 245, 344 and 345. Linear volatile dimethicones are also suitable. Non-

volatile silicones include polydimethyl siloxanes of a viscosity greater than 2 centistoke and silicone copolyols also known as dimethicone copolyol for which Dow Corning 193 is a commercial source. Amounts of the silicones may range  
5 from about 0.01 to about 20, preferably from about 0.5 to about 3% by weight of the impregnated composition.

Cationic conditioning agents in monomeric and polymeric type are also useful for purposes of this invention. Examples of the polymeric type include: cationic cellulose derivatives,  
10 cationic starches, copolymers of a diallyl quaternary ammonium salt and an acrylamide, quaternized vinylpyrrolidone vinylimidazole polymers polyglycol amine condensates, quaternized collagen polypeptide, polyethylene imine, cationized silicon polymer (e.g. Amodimethicone),  
15 cationic silicon polymers provided in a mixture with other components under the trademark Dow Corning 929 (cationized emulsion), copolymers of adipic acid and dimethylaminohydroxypropyl diethylenetriamine, cationic chitin derivatives, cationized guar gum (e.g. Jaguar C-B-S,  
20 Jaguar C-17, Jaguar C-16 etc. manufactured by the Celanese Company), quaternary ammonium salt polymers (e.g. Mirapol A-15, Mirapol AD-1, Mirapol AZ-1, etc., manufactured by the Miranol Division of the Rhone Poulenc Company). Most preferred is polyquaternium-11 available as Luviquat® PQ 11  
25 sold by the BASF Corporation.

Examples of monomeric cationic conditioning agents are salts of the general structure:



wherein  $R^1$  is selected from an alkyl group having from 12 to 22 carbon atoms, or aromatic, aryl or alkaryl groups having from 12 to 22 carbon atoms;  $R^2$ ,  $R^3$ , and  $R^4$  are independently  
10 selected from hydrogen, an alkyl group having from 1 to 22 carbon atoms, or aromatic, aryl or alkaryl groups having from 12 to 22 carbon atoms; and  $X^-$  is an anion selected from chloride, bromide, iodide, acetate, phosphate, nitrate, sulfate, methyl sulfate, ethyl sulfate, tosylate, lactylate,  
15 citrate, glycolate, and mixtures thereof. Additionally, the alkyl groups can also contain ether linkages, or hydroxy or amino group substituents (e.g. the alkyl groups can contain polyethylene glycol and polypropylene glycol moieties). Preferably the anion is phosphate, especially preferred is  
20 hydroxy ethyl cetyl dimonium phosphate available as Luviquat® Mono CP from the BASF Corporation.

Amino silicones quats may similarly be employed. Most preferred is Silquat AD designated by the CTFA as Silicone Quaternium 8, available from Siltech Inc.

Amounts of each cationic agent may range from about 0.05 to about 5%, preferably from about 0.1 to about 3%, optimally from about 0.3 to about 2.5% by weight of the impregnated composition.

5 The disposable, single use personal care cleansing products of the present invention are manufactured by separately or simultaneously adding onto or impregnating into a water insoluble substrate the cleansing composition including lathering surfactants and conditioners, wherein the  
10 resulting product is damp. By "separately" is meant that the surfactants and the conditioners can be added sequentially, in any order without first being combined together. By "simultaneously" is meant that the surfactants and conditioners can be added at the same time, with or  
15 without first being combined together.

The surfactant, conditioners, water-binding agents and any other optional ingredients can be added onto or impregnated into the water insoluble substrate by any means known to those skilled in the art. For example, addition can be  
20 through spraying, laser printing, splashing, dipping, soaking, or coating.

Except in the operating and comparative examples, or where otherwise explicitly indicated, all numbers in this description indicating amounts of material ought to be  
25 understood as modified by the word "about".

The term "comprising" is meant not to be limiting to any subsequently stated elements but rather to encompass non-specified elements of major or minor functional importance. In other words the listed steps, elements or options need

not be exhaustive. Whenever the words "including" or "having" are used, these terms are meant to be equivalent to "comprising" as defined above.

The following examples will more fully illustrate the  
5 embodiments of this invention. All parts, percentages and proportions referred to herein and in the appended claims are by weight unless otherwise illustrated.

EXAMPLE 1

A formula typical of the present invention impregnated onto  
10 a rayon/polyester substrate was formulated with the following components.

TABLE I

Base Formula

Ingredient	Weight %
Deionized Water	26.16
Cocamidopropyl Betaine (Tegobetaine F <sup>®</sup> , 30% Active)	27.00
Sodium Lauroyl Sarcosinate (Hamposyl L-30 <sup>®</sup> , 30% Active)	27.00
Decyl Polyglucoside (Plantareen 2000 N <sup>®</sup> , 50% Active)	18.00
Silicone Quaternium-8 (Hanisquat AD <sup>®</sup> , 40% Active)	0.50
Polyquaternium 10 (Celquat SC-230M <sup>®</sup> )	0.40
Fragrance	0.40
Sodium Lauroyl Lactylate (Pationic 138C <sup>®</sup> )	0.20
Polyquaternium 4 (Celquat L-200 <sup>®</sup> )	0.15
Methyl Paraben	0.15
Soya Sterol (Generol 122 <sup>®</sup> )	0.01
Cholesterol	0.01
Vitamin E Acetate	0.01
Vitamin A Palmitate	0.01

A series of water activities with different water-binding agents are listed for the base formula of Table I. These are recorded in Table II.

5

TABLE II

Sample	Water Activity
Base Formula (100%)	0.977
Base Formula (75%) with glycerin (25%)	0.882
Base Formula (75%) with PEG 9M (25%)	0.976
Base Formula (94%) with Sodium Chloride (6%)	0.925
Base Formula (88%) with Dextrose (12%)	0.964
Base Formula (94%) with Silica (6%)	0.97

The drop in water activity with glycerin is particularly exceptional. Towelettes coated with glycerin performed extremely well in foaming tests as described below.

- 10 The base formula (75%) with glycerin (25%) was coated onto a substrate at 2.0 grams coating per 2.0 grams rayon/polyester sheet (152 mm by 190 mm area).

- 15 Lather quality/stability comparisons were conducted on the glycerin fortified towelette and two commercial products. A modified Ross-Miles foam tester was employed. The towelettes lather parameters were measured on 3 cloths in 200 ml of water. Results are reported in the Table below.

TABLE III

Lather Quality/Stability Comparison

Sample	Lather Quality/Stability*	Lather Height (Ml)
Olay® Daily Facial Cleansing Cloths**	3	400
Dove® Daily Facial Cleansing Cloths	3	550
Base Formula with Glycerin (coated on towelette)	4.5	500

\* Scale of 1 to 5, in order of increasing lather quality/stability.

\*\* Representative of towelettes described by P&G in U.S. Patent 5,951,991, U.S. 5,980,931, U.S. 5,952,043, U.S. 5,863,663 and WO 99/55303.

10 A consumer study was also conducted on two of the towelettes described above. The study was based on response by 118 panelists. Results are reported in Table IV below.

TABLE IV

Consumer Test

Property	% Preferred	
	Base Formula (75%)/Glycerin (25%) (Coated on Towelette)	Olay® Daily Facial Cleansing Cloths
Having a creamy lather	72	28
Lathers quickly	68	32
Leaves skin feeling soft	61	39
Leaves skin feeling moisturized	59	41

Based upon the findings reported in Table IV, there was a significant preference for the glycerin/high water towelette. The Olay<sup>®</sup> towelette with only 3-4% water and a high water activity constant did not provide a sufficiently creamy  
5 lather, lathered slower, left skin feeling less soft and less moisturized than the towelette of the present invention.

#### EXAMPLE 2

More than 60 different materials were evaluated as water-binding agents for use in the compositions for impregnation  
10 into the towelettes. Most did not work including gums, silicas, calcium carbonate, aluminum hydroxides, aluminum carbonates, mica and calcium chloride. These materials either exhibited a too high water activity or thickened the compositions sufficiently to be unusable with the towelettes.  
15 Table VI lists materials which were effective as water-binding agents according to the present invention. Table V is the base formula into which the "water-binding agent" was combined. The base formula was set as a 100% value. For instance, to accommodate 5% of a water-binding agent, 95% of  
20 the total composition was base formula. In this manner all ingredients were maintained proportionally equivalent.



TABLE V

Ingredient	Weight %
Deionized Water	20.60
Water-binding agent	--
Decyl Polyglucoside (Planteren 2000N <sup>®</sup> , 50% Active)	18.00
Sodium Lauroyl Sarcosinate (Hamposyl L-30 <sup>®</sup> , 30% Active)	27.00
Cocoamidopropyl Betaine (Tegobetaine F <sup>®</sup> , 30% Active)	27.00
Polyquaternium (Mackernium <sup>®</sup> 007S)	5.00
Sodium Lauroyl Lactylate (Pationic 138C <sup>®</sup> )	0.30
Silquat AD <sup>®</sup>	1.50
Fragrance	0.40
Preservative	0.20

TABLE VI

Sample (Weight %)	Water Activity
Glycerin (3%)	0.969
Glycerin (6%)	0.959
Glycerin (12%)	0.932
Dextrose (3%)	0.973
Dextrose (6%)	0.967
Dextrose (12%)	0.956
Hexylene Glycol (8%)	0.963
Sodium Chloride (3%)	0.948
Sodium Chloride (6%)	0.918
Sorbitol (3%)	0.969
Sorbitol (6%)	0.967
Base Formula	0.979

5

### EXAMPLE 3

A series of compositions are presented under Table VII reflective of the present invention. These compositions are impregnated onto a non-woven polyester substrate at a 1:1 weight ratio.

TABLE VII

INGREDIENT	SAMPLE (Weight %)						
	A	B	C	D	E	F	G
Hexylene Glycol	16.00	14.00	12.00	--	20.00	20.00	
Butylene Glycol	--	2.00	4.00	16.00		--	20.00
Water	25.00	25.00	25.00	25.00	25.00	30.00	30.00
Polyquaternium 7 (Merquat 2200®)	1.33	1.33	1.33	1.33	--	--	--
Cocamidopropyl Betaine (Tegobetaine CKD®; 82% Active)	17.60	17.60	17.60	17.60	20.00	20.00	20.00
Decyl Polyglucoside (Plantaren 2000N®; 50% Active in Water)	11.00	11.00	11.00	11.00	11.00	--	6.00
Sodium Lauroyl Sarcosinate (Hamposyl L-95®; 94% Active)	17.60	17.60	17.60	17.60	20.00	20.00	20.00
Sodium Lauroyl Lactylate (Pationic 138C®)	1.74	1.74	1.74	1.74	--	--	--
Capric/Caprylic Triglycerides (Miglyol 812®)	2.50	2.50	2.50	2.50	2.77	2.77	2.77
Silicone Quaternium-8 (Silquat AD®; 40% Active in Water)	6.00	6.00	6.00	6.00	--	6.00	--
Fragrance	1.03	1.03	1.03	1.03	1.23	1.23	1.23
Glydant Plus® Liquid (DMDM Hydantoin and Iodopropynyl Butylcarbamate in Butylene Glycol)	0.20	0.20	0.20	0.20	--	--	--

INGREDIENT	SAMPLE (Weight %)							
	H	I	J	K	L	M	N	
Hexylene Glycol	--	3.50	15.00	--	--	--	--	
Butylene Glycol	--	--	--	--	--	34.3	34.3	
Glycerin	20.00	20.00	--	19.3	30.00	--	--	
Water	20.00	20.00	14.08	20.00	18.00	25.00	15.00	
Sodium Laureth Sulfate, 2 mol, 70% in water (Steol® CS 270)	--	20.00	--	--	28.00	15.00	25.00	
Polyquaternium 7 (Merquat 2200®)	--	1.00	--	1.00	--	--	1.00	
Cocamidopropyl Betaine (Tegobetaine CKD®; 82% Active)	16.12	30.00	14.07	27.00	18.00	15.00	20.0	
Decyl Polyglucoside (Plantaren 2000N®; 50% Active in Water)	16.00	--	28.15	--	--	--	--	
Sodium Lauroyl Sarcosinate (Hamposyl L-95®; 94% Active)	14.13	--	--	27.00	--	--	--	
Sodium Lauroyl Lactylate (Pationic 138C®)	2.00	--	--	--	--	--	--	
Capric/Caprylic Triglycerides (Miglyol 812®)	5.00	5.00	5.00	5.00	3.00	--	--	
Dimethicone (D/C 200 fluid)	--	--	--	--	--	10.00	--	
Sunflowerseed oil (Cropure Sunflower)	--	--	20.00	--	--	--	5.00	
Petrolatum	--	--	3.00	--	2.50	--	--	
Silicone Quaternium-8 (Silquat AD®; 40% Active in Water)	6.00	--	--	--	--	--	--	
Fragrance	0.50	0.50	0.50	0.50	0.50	0.50	0.50	
Glydant Plus® Liquid (DMDM Hydantoin and Iodopropynyl Butylcarbamate in Butylene Glycol)	0.25	--	0.20	0.20	--	0.20	0.20	

INGREDIENT	SAMPLE (Weight %)					
	O	P	Q	R	S	
Hexylene Glycol	15.50	19.30	--	--	--	
Butylene Glycol	--	--	--	--	--	
Glycerin	--	--	19.30	--	--	
Water	20.00	35.00	35.00	19.30	19.30	
Sodium Laureth Sulfate, 2 mol, 70% in water (Steol CS® 270)	--	--	--	35.00	35.00	
Polyquaternium 10 (Polymer JR® 400)	2.00	1.00	--	--	1.00	
Polyquaternium 7 (Merquat 2200®)	--	--	1.00	1.00	--	
Cocamidopropyl Betaine (Tegobetaine CKD®;82% Active)	18.00	--	18.00	18.00	--	
Decyl Polyglucoside (Plantaren 2000N®; 50% Active in Water)	16.00	40.00	20.00	20.00	40.00	
Sodium Lauroyl Sarcosinate (Hamposyl L-95®; 94% Active)	18.00	--	--	--	--	
Sodium Lauroyl Lactylate (Pationic 138C®)	1.00	--	--	--	--	
Capric/Caprylic Triglycerides (Miglyol 812®)	3.00	--	--	--	--	
Dimethicone (D/C 200 fluid)	--	--	1.00	1.00	--	
Sunflowerseed oil (Cropure Sunflower)	--	3.00	3.00	3.00	3.00	
Petrolatum	--	1.00	1.00	1.00	1.00	
Silicone Quaternium-8 (Silquat AD®; 40% Active in Water)	6.00	--	1.00	1.00	--	
Fragrance	0.30	0.50	0.50	0.50	0.50	
Glydant Plus® Liquid (DMDM Hydantoin and Iodopropynyl Butylcarbamate in Butylene Glycol)	0.20	0.20	0.20	0.20	0.20	

CLAIMS

1. A substantially damp cleansing product comprising:

(i) a water insoluble substrate; and

5 (ii) a cleansing composition impregnated onto  
the substrate comprising:

(a) at least one lathering surfactant  
present in an amount sufficient to  
foam;

10 (b) water; and

wherein the water is present at greater than 15% by  
weight of the product, but no higher than 40%, and a  
water-binding agent present in an amount sufficient to  
result in a composition having a water activity less than  
15 0.977 but no lower than 0.001.

2. The product according to claim 1 wherein the water-  
binding agent is a polyol or an inorganic salt.

20 3. The product according to claim 1 or claim 2 wherein the  
water-binding agent is glycerin.

4. The product according to any of the preceding claims  
wherein the at least one lathering surfactant is present  
25 in an amount from 0.5 to 60% by weight of total  
impregnated composition deposited upon the water  
insoluble substrate.

5. The article according to any of the preceding claims wherein the water insoluble substrate is a sheet selected from non-woven, woven, hydro-entangled and air entangled substrates.

5

6. The article according to any of the preceding claims further comprising a cationic agent salt in amount from 0.05 to 5% by weight of the total composition.

- 10 7. The product according to any of the preceding claims wherein the water activity is less than 0.94 but no lower than 0.001.

- 15 8. The product according to any of the preceding claims wherein the lathering surfactant is present in an amount from 0.5 to 60% by weight of the composition.